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Extruder Die Head

Patent Claims

1. Extruder die head, preferably a blown film head, comprising a central annular channel (1), which is provided with an annular outlet die (19) and into whose outer limiting wall empty annular slits, which feed a polymer melt and which constitute the smaller diameter openings of truncated channels (12), formed between the internal and external shells of stacked, conical insert members (5, 10, 11, 23, 24),

characterized in

that the annular slits, feeding the polymer melts, also empty into the inside wall of the central annular channel (1), said annular slits being the smaller diameter openings of truncated channels (13), formed between

the internal and external shells of stacked conical internal insert members (4, 8, 9, 21, 22).

2. Blown film head, as claimed in claim 1, characterized in that the internal and external shells of each insert member define the truncated channels for feeding the polymer melts into the central annular channel (1).
3. Blown film head, as claimed in claim 1 or 2, characterized in that the internal and external annular slits lie in the same radial planes.
4. Blown film head, as claimed in claims 1 to 3, characterized in that the internal and external shells of the conical insert members are two counter rotating spiral channels (6), whose depth tapers off in the direction of the opening.